Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D350-591-113
Job Sheet 190059-A

Part No: D350-591-113 **Job Qty:** 1 pcs
Part Name: Heli-Access Step, Short, High Gear

Part Weight: 0 lbs **Status:** Scheduled **Priority:** Medium
Job Created: 3/14/19 **Job Tracking No:**
Due Date: 5/3/19 **Created By:** Linda Lacelle
Type: SOLD **Description:**

Note: DWG DSI 9525 REV A, D2310 REV D IPP Rev:H 04.11.09 Reformat KJ/JLM IPP Rev:E as per ECN10-586 10.06.18 DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Standard Run Hrs	Workcenter/Supplier	Lead Time	Sign-Off
115	**QC 5**	1 pcs		5/3/19	0.00	0.00	QC 5 - 10		DAS 24 9-89
120	**Conventional Mill - 1 - B4B**	1 pcs		5/3/19	0.00	0.00	Conventional Mill - 1 - B4B		FRAN 9-3-
							Conventional Mill - 2 - B4B		
125	**QC 2**	1 pcs		5/3/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		DAS 24 9-89
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		

5162545 Qty 1

				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
130	**QC 8**	1 pcs	5/3/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
135	**Large Fab - Welded Assy-2-B4B**	1 pcs	5/3/19	0.00 0.00	Large Fab - 1 - B4B
					Large Fab - 10 - B4B
					Large Fab - 2 - B4B
					Large Fab - 3 - B4B
					Large Fab - 4 - B4B
					Large Fab - 5 - B4B
					Large Fab - 6 - B4B
					Large Fab - 7 - B4B
					Large Fab - 8 - B4B
					Large Fab - 9 - B4B
140	**QC 5**	1 pcs	5/3/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 42
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
150	**QC 9**	1 pcs	5/3/19	0.00 0.00	QC 9 - 10
					QC 9 - 18

DAS 24 9-89

DAS 43 9-89

					QC 9 - 24	DAS
					QC 9 - 43	43
					QC 9 - 50	9-89
					QC 9 - 9	
165	**Handfinish - 1-1 Chemical-B4B**	1 pcs	5/3/19	0.00 0.22	Handfinish - 1 - 1 - B4B	BEB/9-03-2
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
170	**Large Fab - Steps - 2 - B4B**	1 pcs	5/3/19	0.00 1.03	Large Fab - 1 - B4B	
					Large Fab - 10 - B4B	SLL
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
180	**QC 10**	1 pcs	5/3/19	0.00 0.00	QC 10 - 10	
					QC 10 - 18	MAR 2 0 2019
					QC 10 - 24	DAS
					QC 10 - 43	24
					QC 10 - 50	9-89
					QC 10 - 58	
					QC 10 - 9	
190	**QC 5**	1 pcs	5/3/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	MAR 2 0 2019
					QC 5 - 3	
					QC 5 - 42	DAS
					QC 5 - 43	24
					QC 5 - 49	9-89
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	

					QC 5 - 30	
					QC 5 - 40	
200	**Handfinish - 1-2- Chemical-B4B**	1 pcs	5/3/19	0.00 0.22	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	D.R 19/03/21
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
210	**Powdercoat - 1 White GI(A)-B4B**	1 pcs	5/3/19	0.00 0.21	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BK 19-03-21.
					Powdercoat - 4 - B4B	
220	**Handfinish - 3-1- WingWalk-B4B**	1 pcs	5/3/19	0.00 0.22	Handfinish - 3 - 1 - B4B	
					Handfinish - 3 - 2 - B4B	BEB 19-03-21
					Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
230	**QC 3**	1 pcs	5/3/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	DAS
					QC 3 - 40	MAR 2 6 2019 40
					QC 3 - 19	9-89
240	**Packaging 1-1 - Pick Kit - B4B**	1 pcs	5/3/19	0.00 0.00	Packaging 1 - 1 - B4B	DAS
					Packaging 1 - 2 - B4B	46 MAR 2 9 2019
					Packaging 1 - 3 - B4B	9-89
					Packaging 1 - 4 - B4B	
					Packaging 1 - 5 - B4B	
					Packaging 1 - 6 - B4B	
					Packaging 1 - 7 - B4B	

				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36	
250 **QC 4**	1 pcs	5/3/19	0.00 0.00	QC 4 - 28	
				QC 4 - 42	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	DAS 46 9-89 MAR 2 9 2019
255 **DC - 1 - B4B**	1 pcs	5/3/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	DAS 21 MAR 2 9 2019
260 **Packaging 3-1 - Stock - B4B**	1 pcs	5/3/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	DAS MAR 2 9 2019
				Packaging 3 - 3 - B4B	46
				Packaging 3 - 4 - B4B	9-89
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	

				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
270 **QC 21 - FG**	1 pcs	5/3/19	0.00 0.00	QC 21 - FG - 21	DAR
				QC 21 - FG - 70	21
				QC 21 - SA - 53	

MAR 2 9 2019

Part Op **115** -
Descriptions: **120** - 1- OPEN HOLE FOR BUSHING TO SIZE AS PER DWG AND C'SINK.
135 - 1- Weld Fwd end cap and bushing as per Dwg D2310 A/R AL ROD Batch:_____ 2- Grind end cap and bottom bushing welds flush 3- Machine top weld on bushing flush as per dwg.
140 - (QC5- Inspect part completeness to step on W/O)
165 - (Chemical Conversion Coat per QSI005 4.1)
170 - (Weld per dwg A/R Aluminum rod Batch:_____) 1-Rivet as per Dwg D2310 3-Weld Aft end cap as per Dwg D2310 A/R AL ROD Batch:_____ 4-Grind end cap welds flush
180 - (QC10- Inspect visual per QSI004- ground welds)
190 - (QC5- Inspect part completeness to step on W/O)
200 - (Chemical Conversion Coat per QSI005 4.1)
210 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 11:15 O.V.T. 330° M 138947. FINISH TIME: 11:45.
220 - (Wing Walk as per dwg QSI005 4.4 Batch S163438 ***Install Dart labels after wing walk***
230 - (QC3- Inspect Part Finish) ***Install Dart labels after wing walk***
240 - (Pick Kit)
250 - (QC4- 100% Inspect kits for completeness)
255 - (Document Control) Photocopy bluefile & type labels per PPP D350-591-113 CHG005
260 - (Identify as per dwg & Stock Location:_____) Identify and pack for shipping as per PPP D350-591-113
270 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2582	Hi-Skid Step Leg Assembly	1 pcs (1 ea)	170-Large Fab - Steps - 2 - B4B	S152404
D2673-34	End Plate	1 pcs (1 ea)	170-Large Fab - Steps - 2 - B4B	S161432
MS20600-AD4W3	Cherry Rivet	16 Ea (16 ea)	170-Large Fab - Steps - 2 - B4B	S155667
K591-113	Short Step Installation	1 pcs (1 ea)	240-Packaging 1-1 - Pick Kit - B4B	S166854

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
170-Large Fab - Steps - 2 - B4B	D2582	1	10	0
	D2673-34	1	50	0
	MS20600-AD4W3	16	693	0
240-Packaging 1-1 - Pick Kit - B4B	K591-113	1	2	0

Part Specifications

Specifications could not be found.

170-8757

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D350-591-113
Job Sheet 190059

Part No: D350-591-113 **Job Qty:** 10 pcs
Part Name: Heli-Access Step, Short, High Gear

Part Weight: 0 lbs
Job Created: 2/4/19
Due Date: 5/3/19
Type: SOLD

Status: Scheduled
Job Tracking No:
Created By: Marie Lajeunesse
Description: AIRBUS

Priority: Medium

Note: DWG DSI 9525 REV A, D2310 REV D IPP Rev:H 04.11.09 Reformat KJ/JLM IPP Rev:E as per ECN10-586 10.06.18 DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Standard Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
110	**Large Fab - Steps - 1**	10 pcs		5/3/19	0.00	20.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		MAR 0 6 2019
							Large Fab - 3		
							Large Fab - 4		DAS 24 9-89
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
115	**QC 5**	10 pcs		5/3/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		DAS
							QC 5 - 68		MAR 0 6 2019 68 9-89
							QC 5 - 9		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		

				~~QC 9 - 9~~	
				QC 5 - 50	
				QC 5 - 30	
120 **Conventional Mill - 1 - B4B**	10 pcs	5/3/19	0.00 0.00	Conventional Mill - 1 - B4B	
125 **QC 2**	10 pcs	5/3/19	0.00 0.00	QC 2 - 1	
				QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 54	
				QC 2 - 56	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
130 **QC 8**	10 pcs	5/3/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
135 **Large Fab - Welded Assy-2-**	10	5/3/19	0.00 0.00	Large Fab - 2 - B4B	

	B4B	pcs				
140	**QC 5**	10 pcs	5/3/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 38	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
150	**QC 9**	10 pcs	5/3/19	0.00 0.00	QC 9 - 10	
					QC 9 - 18	
					QC 9 - 24	
					QC 9 - 43	
					QC 9 - 50	
					QC 9 - 9	
165	**Handfinish - 1-1 Chemical-B4B**	10 pcs	5/3/19	0.00 2.22	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
170	**Large Fab - Steps - 2 - B4B**	10 pcs	5/3/19	0.00 10.32	Large Fab - 1 - B4B	

					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
180	**QC 10**	10 pcs	5/3/19	0.00 0.00	QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 38	
					QC 10 - 43	
					QC 10 - 50	
					QC 10 - 58	
					QC 10 - 9	
190	**QC 5**	10 pcs	5/3/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 38	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
200	**Handfinish - 1-2- Chemical-B4B**	10 pcs	5/3/19	0.00 2.22	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	

					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
210	**Powdercoat - 1 White GI(A)- B4B**	10 pcs	5/3/19	0.00 2.06	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
220	**Handfinish - 3-1- WingWalk- B4B**	10 pcs	5/3/19	0.00 2.22	Handfinish - 3 - 1 - B4B	
					Handfinish - 3 - 2 - B4B	
					Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
230	**QC 3**	10 pcs	5/3/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 38	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 6	
					QC 3 - 68	
					QC 3 - 9	
240	**Packaging 1-1 - Pick Kit - B4B**	10 pcs	5/3/19	0.00 0.00	Packaging 1 - 1 - B4B	
					Packaging 1 - 2 - B4B	
					Packaging 1 - 3 - B4B	
					Packaging 1 - 4 - B4B	
					Packaging 1 - 5 - B4B	
					Packaging 1 - 6 - B4B	
					Packaging 1 - 7 - B4B	
					Packaging 1 - 8 - B4B	
					Packaging 1 - 9 - B4B	
					Packaging 1 - 10 - B4B	
					Packaging 1 - 11 - B4B	
					Packaging 1 - 12 - B4B	
					Packaging 1 - 13 - B4B	
					Packaging 1 - 14 - B4B	
					Packaging 1 - 15 - B4B	
					Packaging 1 - 16 - B4B	
					Packaging 1 - 17 - B4B	
					Packaging 1 - 18 - B4B	
					Packaging 1 - 19 - B4B	
					Packaging 1 - 20 - B4B	
					Packaging 1 - 21 - B4B	

					Packaging 1 - 22 - B4B	
					Packaging 1 - 23 - B4B	
					Packaging 1 - 24 - B4B	
					Packaging 1 - 25 - B4B	
					Packaging 1 - 26 - B4B	
					Packaging 1 - 27 - B4B	
					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
250	**QC 4**	10 pcs	5/3/19	0.00 0.00	QC 4 - 26	
					QC 4 - 28	
					QC 4 - 38	
					QC 4 - 42	
					QC 4 - 58	
					QC 4 - 6	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
255	**DC - 1 - B4B**	10 pcs	5/3/19	0.00 0.00	DC - 1 - B4B	
					DC - 2 - B4B	
260	**Packaging 3-1 - Stock - B4B**	10 pcs	5/3/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	

					Packaging 3 - 35 - B4B	
270 **QC 21 - FG**	10 pcs	5/3/19	0.00	0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - SA - 53	

Part Op Descriptions:
110 - (Fabricate per Drwg) 1- Cut D2244 extrusion to 62.00" long as per Dwg D2310 2- Drill extrusion as per Dwg D2310 using drill Jig DT8230
115 -
120 - 1- OPEN HOLE FOR BUSHING TO SIZE AS PER DWG AND C'SINK.
135 - 1- Weld Fwd end cap and bushing as per Dwg D2310 A/R AL ROD Batch:_____ 2- Grind end cap and bottom bushing welds flush 3- Machine top weld on bushing flush as per dwg.
140 - (QC5- Inspect part completeness to step on W/O)
165 - (Chemical Conversion Coat per QSI005 4.1)
170 - (Weld per dwg A/R Aluminum rod Batch:_____) 1-Rivet as per Dwg D2310 3-Weld Aft end cap as per Dwg D2310 A/R AL ROD Batch:_____ 4-Grind end cap welds flush
180 - (QC10- Inspect visual per QSI004- ground welds)
190 - (QC5- Inspect part completeness to step on W/O)
200 - (Chemical Conversion Coat per QSI005 4.1)
210 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ FINISH TIME: _____
220 - (Wing Walk as per dwg QSI005 4.4 Batch_____) ***Install Dart labels after wing walk***
230 - (QC3- Inspect Part Finish) ***Install Dart labels after wing walk***
240 - (Pick Kit)
250 - (QC4- 100% Inspect kits for completeness)
255 - (Document Control) Photocopy bluefile & type labels per PPP D350-591-113 CHG005
260 - (Identify as per dwg & Stock Location:_____) Identify and pack for shipping as per PPP D350-591-113
270 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	10 pcs (1 ea)	110-Large Fab - Steps - 1	164533
D2275	Bushing	10 pcs (1 ea)	110-Large Fab - Steps - 1	5016564 → 2 5158848 → 8
D2673-34	End Plate	20 pcs (2 ea)	110-Large Fab - Steps - 1	5149847
D2582	Hi-Skid Step Leg Assembly	10 pcs (1 ea)	170-Large Fab - Steps - 2 - B4B	
D2673-34	End Plate	10 pcs (1 ea)	170-Large Fab - Steps - 2 - B4B	5149847
MS20600-AD4W3	Cherry Rivet	160 Ea (16 ea)	170-Large Fab - Steps - 2 - B4B	
K591-113	Short Step Installation	10 pcs (1 ea)	240-Packaging 1-1 - Pick Kit - B4B	

20 TOTAL
2 PCS PER STEP

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D2244-116	10	93	0
	D2275	10	14	0
	D2673-34	20	24	0
170-Large Fab - Steps - 2 - B4B	D2582	10	10	0
	D2673-34	10	24	0
	MS20600-AD4W3	160	701	0
240-Packaging 1-1 - Pick Kit - B4B	K591-113	10	2	0

Part Specifications

Specifications could not be found.

008476

BE LIVE COLLECTIONS PUNTA CANA

DART
AEROSPACE

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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S162545

Part: D350-591-113
Job No: 190059-A
Serial No/Batch: S159577
Revision:
Inspector:
Exp Date:
Instructions:

Date: 03/20/19

Change Record

Part Number: D350-591-113 (K591-113 PRODUCTION KIT)

Description: HELI-ACCESS STEP, HIGH SKID, SHORT STEP

CHG #	DATE	BY	RELEVANT DOCUMENTS	ECN #
001	99.04.13	CS/KE	D350-591 REV D, DSI 9029, DSI 9063, DSI 9116 REV A,	
			DSI 9065 REV B, MDL-D350-591 REV B	
002	01.04.12	DS	DSI 9065 REV C (NO D2346 SPACERS)	
003	02.11.26	DS	D350-591 REV E (ADD D2856-400-720 ABRASION STRIPS)	
004	08.01.10	KJ	D2278 REV F, D2582 REV B, D3270 REV A, DR-D350-591 REV N	1105
005	10.06.17	KJ	DSI 9525 REV A, D4127 REV B	10-586